INTERNATIONAL STANDARD

ISO 6194-1

Second edition
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Rotary shaft lip-type seals incorporating elastomeric sealing elements —

Part 1: Nominal dimensions and tolerances

Bagues d'étanchéité à lèvres pour arbres tournants incorporant des éléments d'étanchéité en élastomère —
Partie 1: Dimensions nominales et tolérances

Reference number
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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 6194-1 was prepared by Technical Committee ISO/TC 131, *Fluid power systems*, Subcommittee SC 7, *Sealing devices*.

This second edition cancels and replaces the first edition (ISO 6194-1:1982), which has been technically revised.

ISO 6194 consists of the following parts, under the general title *Rotary shaft lip-type seals incorporating elastomeric sealing elements*:

— *Part 1: Nominal dimensions and tolerances*

— *Part 2: Vocabulary*

— *Part 3: Storage, handling and installation*

— *Part 4: Performance test procedures*

— *Part 5: Identification of visual imperfections*

Introduction

Rotary shaft lip-type seals are used to retain fluid, e.g. lubricant, in equipment where the differential pressure is relatively low. Typically the shaft rotates, and the housing is stationary, although in some applications the shaft is stationary, and the housing rotates.

Dynamic sealing is normally the result of a designed interference-fit between the shaft and a flexible element incorporated in the seal.

Similarly, a designed interference-fit between the outside diameter of the seal, and the diameter of the housing bore, retains the seal and prevents static leakage.

Careful storage, handling, and proper installation of all seals are necessary to avoid hazards, both prior to and during installation, which would adversely affect service life.

Rotary shaft lip-type seals incorporating elastomeric sealing elements —

Part 1:
Nominal dimensions and tolerances

1 Scope

This part of ISO 6194 describes seals utilising elastomeric sealing elements. They are considered suitable for use under low-pressure conditions (see 6.1).

This part of ISO 6194 shows seal types and examples. It also specifies the nominal dimensions and tolerances of the seals, shafts and housings, as well as a dimensional identification code.

NOTE ISO 6194 is complementary to ISO 16589 which covers seals incorporating thermoplastic sealing elements.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 286-2, *ISO system of limits and fits — Part 2: Tables of standard tolerance grades and limit deviations for holes and shafts*

ISO 5598, *Fluid power systems and components — Vocabulary*

ISO 6194-2, *Rotary shaft lip-type seals — Part 2: Vocabulary*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 5598 and ISO 6194-2 apply.

4 Symbols

The symbols used in this part of ISO 6194 are as follows:

a housing-bore depth;

d nominal inside diameter of the inner case;

b nominal seal width;

c housing chamfer length;

D_1 nominal diameter of the shaft to be used with the seal;

d_m minor diameter at the shaft lead-in chamfer;

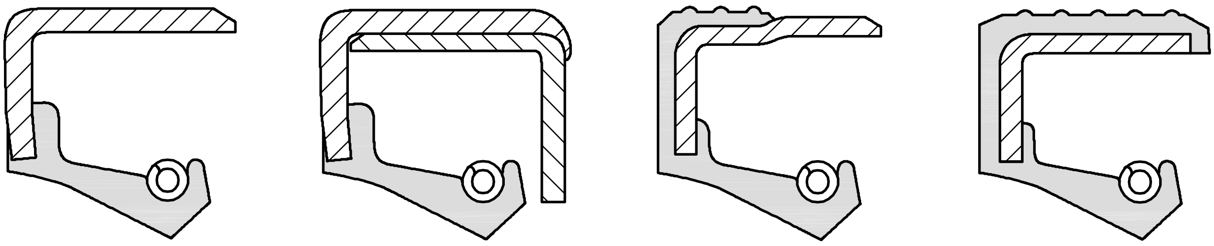
D_2 nominal diameter of the housing bore and outer diameter of the seal;

r housing corner radius.

5 Seal types and examples

5.1 Seal outside-diameter construction

The constructions shown in Figure 1 show four basic types.



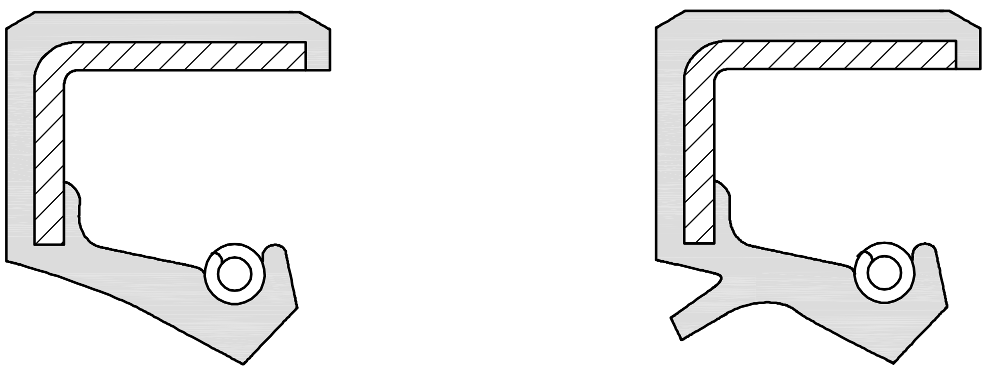
Type 1	Type 2	Type 3	Type 4
Metal-cased	Metal-cased with inner case	Semi-rubber-covered metal-cased	Rubber-covered metal-cased

NOTE Because of some variations in design details, or seals made by different manufacturers, the constructions shown are intended only to be representative of the basic types.

Figure 1 — Four basic types of outside-diameter construction

5.2 Sealing lip arrangements

Examples of sealing lip arrangements are shown in Figure 2.



a) Single lip **b) Single lip with protection lip**

Figure 2 — Sealing lip arrangements

The sealing lip arrangements shown in Figure 2 can be used with each seal outside-diameter construction shown in Figure 1.

Hydrodynamic aids on the main lip may be incorporated by some manufacturers in certain applications.

The design of the sealing lip should be agreed between the manufacturer and purchaser.

NOTE In view of some variations in design detail, or seals made by different manufacturers, the constructions shown are intended only as representative examples of the basic types.

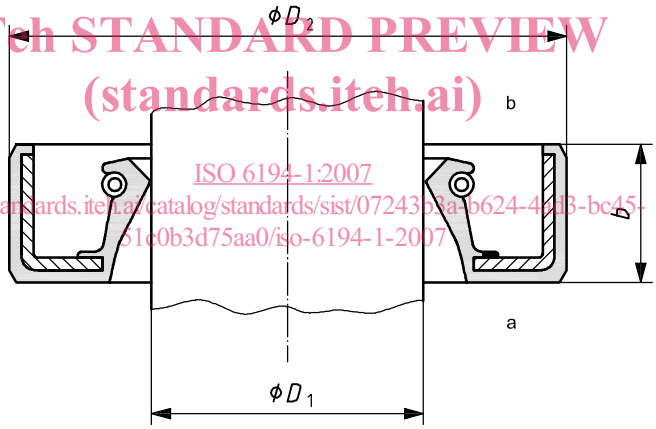
6 Pressure and nominal dimensions

6.1 Pressure

Seals of this type are normally used with atmospheric pressure on the air side, and sealing fluids at pressures from 0 kPa to 30 kPa (0,3 bar) above atmospheric pressure. The user should consult the seal manufacturer regarding use at other pressures.

6.2 Nominal dimensions

The nominal dimensions of the seals are shown in Figure 3 and given in Table 1.



Key

D_1 nominal diameter of the shaft to be used with the seal

D_2 nominal diameter of the housing bore and outer diameter of the seal

b nominal seal width

a Air side.

b Fluid side.

Figure 3 — Seal

Table 1 — Nominal dimensions

Dimensions in millimetres

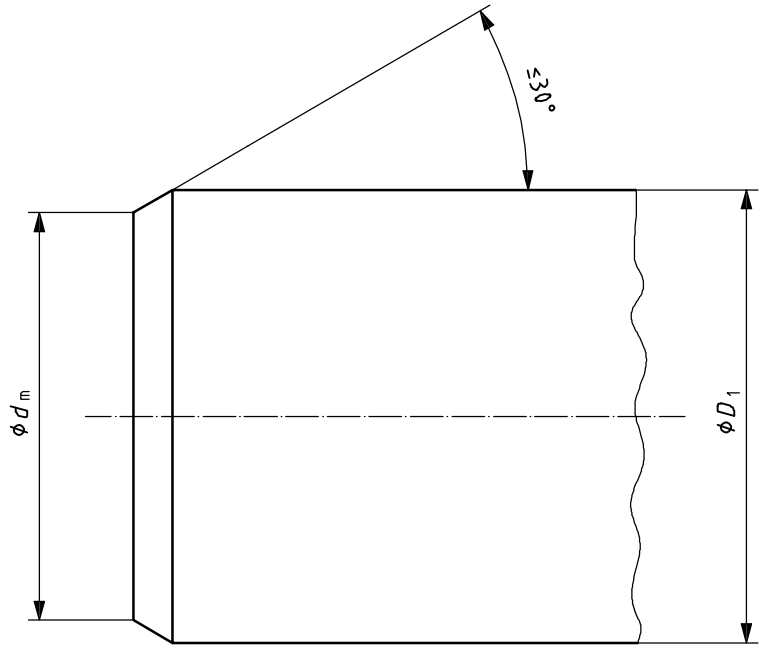
D_1	D_2	b [a]	D_1	D_2	b [a]	D_1	D_2	b [a]	D_1	D_2	b [a]
6	16	7	25	52	7	45	65	8	120	150	12
6	22	7	28	40	7	50	65	8	130	160	12
7	22	7	28	47	7	50	72	8	140	170	15
8	22	7	28	52	7	55	72	8	150	180	15
8	24	7	30	42	7	55	80	8	160	190	15
9	22	7	30	47	7	60	80	8	170	200	15
10	22	7	30	52	7	60	85	8	180	210	15
10	25	7	32	45	8	65	85	10	190	220	15
12	24	7	32	47	8	65	90	10	200	230	15
12	25	7	32	52	8	70	90	10	220	250	15
12	30	7	35	50	8	70	95	10	240	270	20
15	26	7	35	52	8	75	95	10	260	300	20
15	30	7	35	55	8	75	100	10	280	320	20
15	35	7	38	55	8	80	100	10	300	340	20
16	30	7	38	58	8	80	110	10	320	360	20
18	30	7	38	62	8	85	110	12	340	380	20
18	35	7	40	55	8	85	120	12	360	400	20
20	35	7	40	62	8	90	120	12	380	420	20
20	40	7	42	55	8	95	120	12	400	440	20
22	35	7	42	62	8	100	125	12	450	500	25
22	40	7	45	62	8	110	140	12	480	530	25
22	47	7									
25	40	7									
25	47	7									

[a] b may be increased to permit the use of more complex seal configurations.

7 Shafts

7.1 Shaft ends

The end of the shaft shall be provided with a lead-in chamfer as shown in Figure 4 and given in Table 2 and shall be free from burrs, sharp edges or rough machining marks.



Key

d_m minor diameter at the shaft lead-in chamfer

D_1 nominal diameter of the shaft to be used with the seal

Figure 4 — Shaft lead-in chamfer

Table 2 — Shaft lead-in chamfer

Dimensions in millimetres

Shaft diameter		Shaft diameter	
D_1	d_m max.	D_1	d_m max.
$D_1 \leqslant 10$	$D_1 - 1{,}5$	$50 < D_1 \leqslant 70$	$D_1 - 4{,}0$
$10 < D_1 \leqslant 20$	$D_1 - 2{,}0$	$70 < D_1 \leqslant 95$	$D_1 - 4{,}5$
$20 < D_1 \leqslant 30$	$D_1 - 2{,}5$	$95 < D_1 \leqslant 130$	$D_1 - 5{,}5$
$30 < D_1 \leqslant 40$	$D_1 - 3{,}0$	$130 < D_1 \leqslant 240$	$D_1 - 7{,}0$
$40 < D_1 \leqslant 50$	$D_1 - 3{,}5$	$240 < D_1 \leqslant 480$	$D_1 - 11{,}0$

Assembly tools are specified in ISO 6194-3 and should be used to ensure that the sealing lip is not damaged.

If a radius is used instead of a lead-in chamfer, its value shall be between 1,8 mm and 3,0 mm.

7.2 Diametral tolerance

The shaft shall have a diametral tolerance not greater than h11 (see ISO 286-2).